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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

008376

D4634-045
Job Sheet 186122



Part No: D4634-045

Job Qty: 1 pcs

Part Name: Aft, Center Ceiling Panel Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/12/18

Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: D4634 REV.G IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Document release DL VERIFIED
BY:JLM IPP Rev C 13/07/09 Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg
update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - 1	1 pcs	12/7/18	12/7/18	0.00	0.50	Small Fab - 1			DAS 58 MAR 14 2019 9-89
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
110	Small Fab - 2 - B4B	1 pcs	12/7/18	12/7/18	0.00	0.50	Small Fab - 1 - B4B			DAS 58 APR 08 2019 9-89
							Small Fab - 2 - B4B			
							Small Fab - 3 - B4B			
							Small Fab - 4 - B4B			
							Small Fab - 5 - B4B			
							Small Fab - 6 - B4B			
							Small Fab - 7 - B4B			
120	QC 5	1 pcs	12/7/18	12/7/18	0.00	0.00	QC 5 - 10			DAS 40 APR 08 2019
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 38			
							QC 5 - 42			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			

130 Packaging 3-1 - Stock - B4B 1 pcs	12/7/18	0.00 0.00	QC 5 - 50	
			QC 5 - 30	
			Packaging 3 - 1 - B4B	DAS
			Packaging 3 - 2 - B4B	69
			Packaging 3 - 3 - B4B	9-89
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	DAS
140 QC 21 - SA 1 pcs	12/7/18	0.00 0.00	QC 21 - SA - 21	21
			QC 21 - SA - 70	9-89

APR 15 2019

Part Op 100 - (Small Fab)

Descriptions: 110 - (Small Fab) ***BEFORE INTALLING D4728-055, APPLY A 3/16" SEEM OF PLASTIC-WELD 2 ON TOTAL LENGHT OF PART ON EANCH SIDE OF LIGHT, LET DRY FOR ONE HOUR*** PLASTIC-WELD 2 BATCH : _____

1- Assemble as per Dwg D4634-045 2- install No Smoking & seat belt symbols 3- Install led lights 4- Install Air valves 5- Install Wiring Harness

120 - (QC5- Inspect part completeness to step on W/O)

130 - Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2351-20-27-C3C	Stud	1 Ea (1 ea)	100-Small Fab - 1	5007846
50-009-2	Grommet	1 Ea (1 ea)	100-Small Fab - 1	5034461 X1
D4634-145	Aft, Center Ceiling Replacement Panel Assembly	1 pcs (1 ea)	100-Small Fab - 1	5152919
D4646-1	Plenum Cap Assembly	2 pcs (2 ea)	100-Small Fab - 1	5138377
D4652-3	Mounting Nut	2 Ea (2 ea)	100-Small Fab - 1	5153919
D4652-5	Air Valve, 1.25 Id Disk Type	2 Ea (2 ea)	100-Small Fab - 1	5153960
D4728-049	Advisory Light, Aft	1 pcs (1 ea)	100-Small Fab - 1	5018471
D4728-055	Cabin Lights #3	1 pcs (1 ea)	100-Small Fab - 1	5034462
PLT1.5M-M	Tie Wrap	10 Ea (10 ea)	100-Small Fab - 1	5018471

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	2351-20-27-C3C	1	26	0
	50-009-2	1	149	0
	D4634-145	1	0	0
	D4646-1	2	32	0
	D4652-3	2	202	0
	D4652-5	2	2	0
	D4728-049	1	11	0
	D4728-055	1	0	0
	PLT1.5M-M	10	2,032	0
Part Specifications				
Specifications could not be found.				

Plex 1/24/19 9:02 AM Dart.Hadley.Shannon



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D4634-045
Job Sheet 186122



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Status: New

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Job Tracking No:

Due Date: 12/7/18

Created By: Jesse White

Type: Stock

Description: SIOP

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BY:JLM IPP Rev C 13/07/09 Dwg Update DL ver: DD IPP Rev D Dwg Update 13/12/23 DL IPP REV E Dwg
update 14/01/09 DL IPP Rev F Dwg. update 14/02/03 DL IPP Rev G Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/7/18	0.00	0.00	Start Up Small Fab		
100	Small Fab	1 pcs		12/7/18	0.00	0.50	Small Fab		
110	Small Fab	1 pcs		12/7/18	0.00	0.50	Small Fab		
120	QC	1 pcs		12/7/18	0.00	0.00	QC5		
130	Packaging	1 pcs		12/7/18	0.00	0.00	Packaging3		
140	QC21-SA	1 Ea		12/7/18	0.00	0.00	QC21		

Part Op 110 - ***BEFORE INTALLING D4728-055, APPLY A 3/16" SEEM OF PLASTIC-WELD 2 ON TOTAL LENGHT OF PART
Descriptions: ON EANCH SIDE OF LIGHT, LET DRY FOR ONE HOUR*** PLASTIC-WELD 2 BATCH : _____ 1-
Assemble as per Dwg D4634-045 2- install No Smoking & seat belt symbols 3- Install led lights 4- Install Air valves 5-
Install Wiring Harness

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2351-20-27-C3C	Stud	1 Ea (1 ea)	90-Start up Operation	
50-009-2	Grommet	1 Ea (1 ea)	90-Start up Operation	
D4634-145	Aft, Center Ceiling Replacement Panel Assembly	1 Ea (1 ea)	90-Start up Operation	
D4646-1	Plenum Cap Assembly	2 Ea (2 ea)	90-Start up Operation	
D4652-3	Mounting Nut	2 Ea (2 ea)	90-Start up Operation	
D4652-5	Air Valve, 1.25 Id Disk Type	2 Ea (2 ea)	90-Start up Operation	
D4728-049	Advisory Light, Aft	1 Ea (1 ea)	90-Start up Operation	
D4728-055	Cabin Lights #3	1 Ea (1 ea)	90-Start up Operation	
PLT1.5M-M	Tie Wrap	10 Ea (10 ea)	90-Start up Operation	

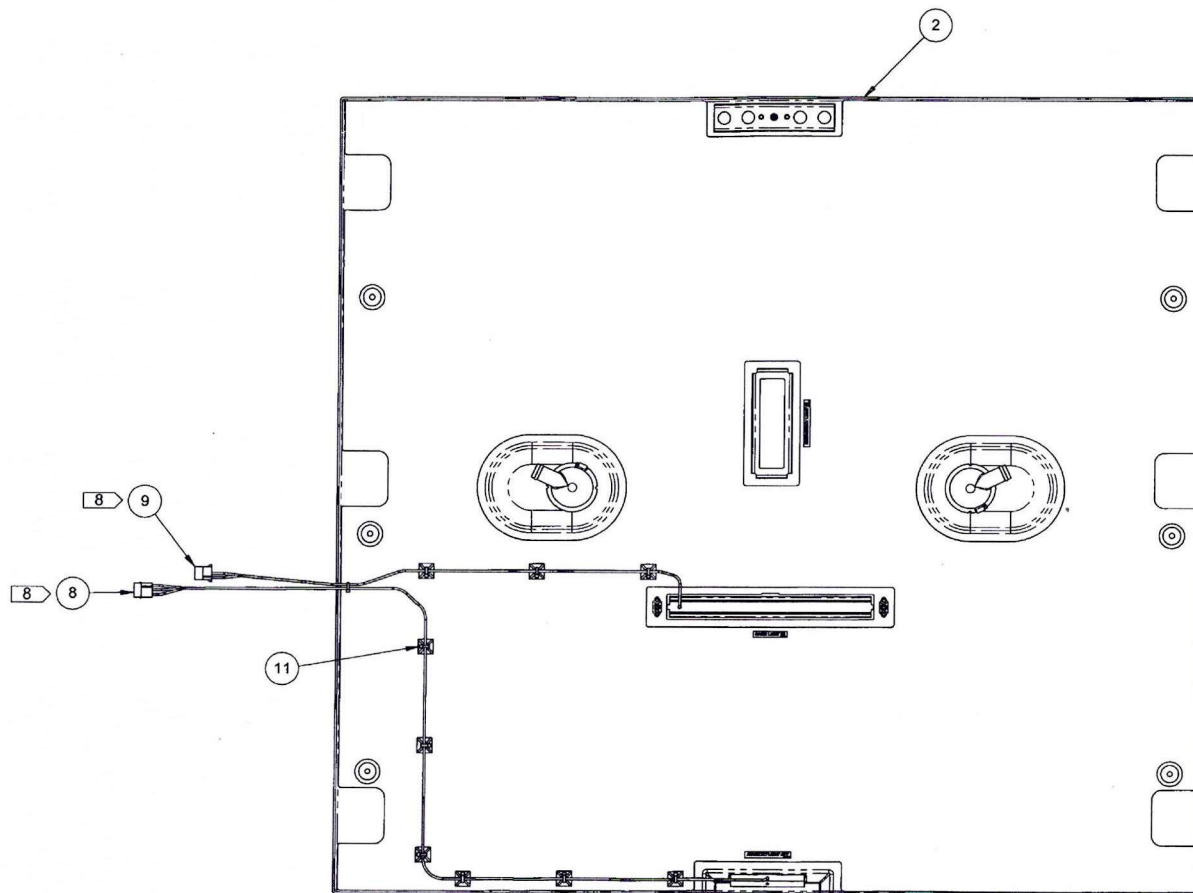
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2351-20-27-C3C	1	37	0
	50-009-2	1	185	0
	D4634-145	1	0	0
	D4646-1	2	1	0
	D4652-3	2	207	0
	D4652-5	2	11	0
	D4728-049	1	11	0
	D4728-055	1	1	0
	PLT1.5M-M	10	6	0

Part Specifications

Specifications could not be found.

Plex 11/12/18 10:34 AM dart.white.jesse



D4634-045 AFT. CENTER CEILING PANEL ASSY
AUXILIARY VIEW

RELEASED

2015 JAN 26 *q*

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D4634	REV. G SHEET 6 OF 17
MFG. APPR.	DL	TITLE CENTER CEILING PANELS	SCALE NTS
APPROVED	HS	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	DS		
DATE	14.11.28		



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Container No: S162352



Part: D4634-045

Job No: 186122

Serial No/Batch: S162352

Revision: G

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/14/19